

**Work Order ID 59507**

Friday, June 04, 2010 3:02:37 PM

Page 1

Item ID: D4006-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Tank Top Support Assembly

Start Date: 6/4/2010 Start Qty: 1.00

Required Date: 6/10/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4006

A

100

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4006

Signature: [Handwritten Signature]  
Date: 6/10/06/28

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Signature: [Handwritten Signature]

Signature: [Handwritten Signature]

120

0.00



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

Powder Coating

Signature: [Handwritten Signature]  
Start Time: 9:15  
Oven Temperature: 320°  
Finish Time: 9:45

Signature: [Handwritten Signature]  
Date: 10-7-7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 59507

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Item ID: D4006-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Tank Top Support Assembly					
Start Date: 6/4/2010	Start Qty: 1.00				
Required Date: 6/10/2010	Req'd Qty: 1.00				
Reference:					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run
	QC:	Date:	SPC (Y/N):	Date:	Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 H 10/07/07				X 1	Ø		
140  HandFinish Hand Finishing	Memo 341300 contact cement Batch H113124 1- Apply glue and install Foam as per dwg 2- Install anchor nuts as per dwg	0.00 0.00 S 10/07/14				⑩			
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 S 10/07/14				⑩			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 59507**

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Item ID: D4006-041

Accept



Setup Start



Revision ID:

Item Name: Tank Top Support Assembly

Stop



Start Date: 6/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 1/0

0.00



Packaging

Memo

0.00

Packaging

6/7/14 (1)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

7/10/15

MF  
10-7-14

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 04, 2010 3:02:42 PM

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Work Order ID: 59507

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD  
10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4006-1

Manufactured

No

100

Each

2.0000

1

1

1

1

1



Angle

Location

Loc Qty

Loc Code

ENG

2

55872

2

D4006-3

Manufactured

No

100

Each

4.0000

2

2

2

2

2



Channel

Location

Loc Qty

Loc Code

ENG

4

55660

4

MS20470AD4-5

Purchased

No

100

Each

1,921.000

8

8

8

8

8



Rivet, Universal Head

M114761

(8x)

Location

Loc Qty

Loc Code

ST309

1500

114761

1500

ST319

421

111916

121

114718

300

D4006-5

Manufactured

No

140

Each

2.0000

1

1

1

1

1



Foam

Location

Loc Qty

Loc Code

ENG

2

55659

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Friday, June 04, 2010 3:02:42 PM

Page 2 / 2

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Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD  
10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD5-4

3-3

Replacement  
Item ID

Mfg/  
Purch

Purchased

Bin  
Item  
No

Primary  
Location

Last  
Location

Route  
Seq ID  
140

Unit of  
Measure  
Each

Qty on  
Hand  
6,712.000

Qty per Kit  
4

Total  
Qty

Qty  
Issued

Date  
Issued

Status

RIVET

17681 (YK)

Location

ST316

104374

110398

Loc Qty

6712

2712

4000

Loc Code

MS21059L4

Purchased

No

140

Each

53.0000

2

2

Nutplate

Location

ST301

114718

ST302

112243

Loc Qty

30

30

23

23

Loc Code

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

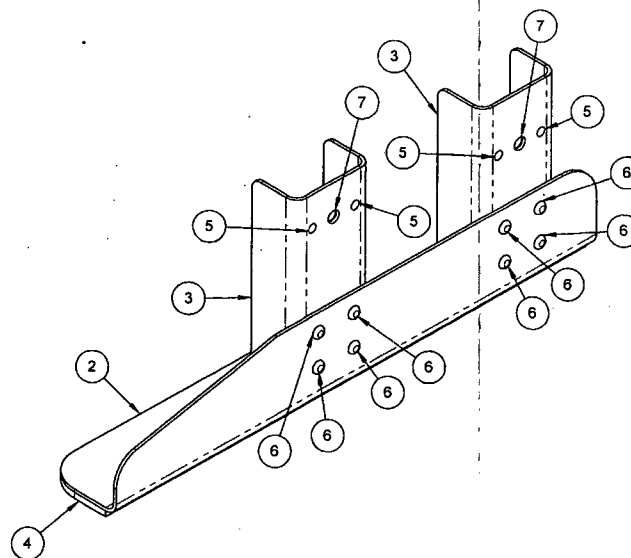
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3-4	RIVET	
6	8	MS20470AD4	RIVET	
7	2	MS21059-4	ANCHOR NUT	



**D4006-041 TANK TOP SUPPORT ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59507  
BS10-6-07

**RELEASED**  
2010-05-05  
*MJ*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3  
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

A	NEW ISSUE		10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4006</b>	REV. A
TITLE <b>UPPER RESTRAINT</b>	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

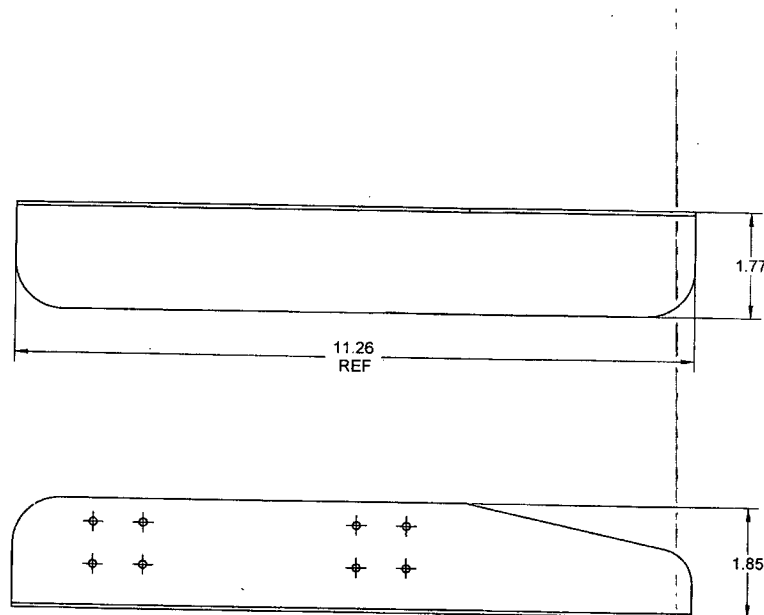
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-1	REF JCA-M47-2-01



**D4006-1 ANGLE**

**NOTES:**

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4006</b>	REV. A
MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE <b>UPPER RESTRAINT</b>	SCALE
DE APPR.			NTS
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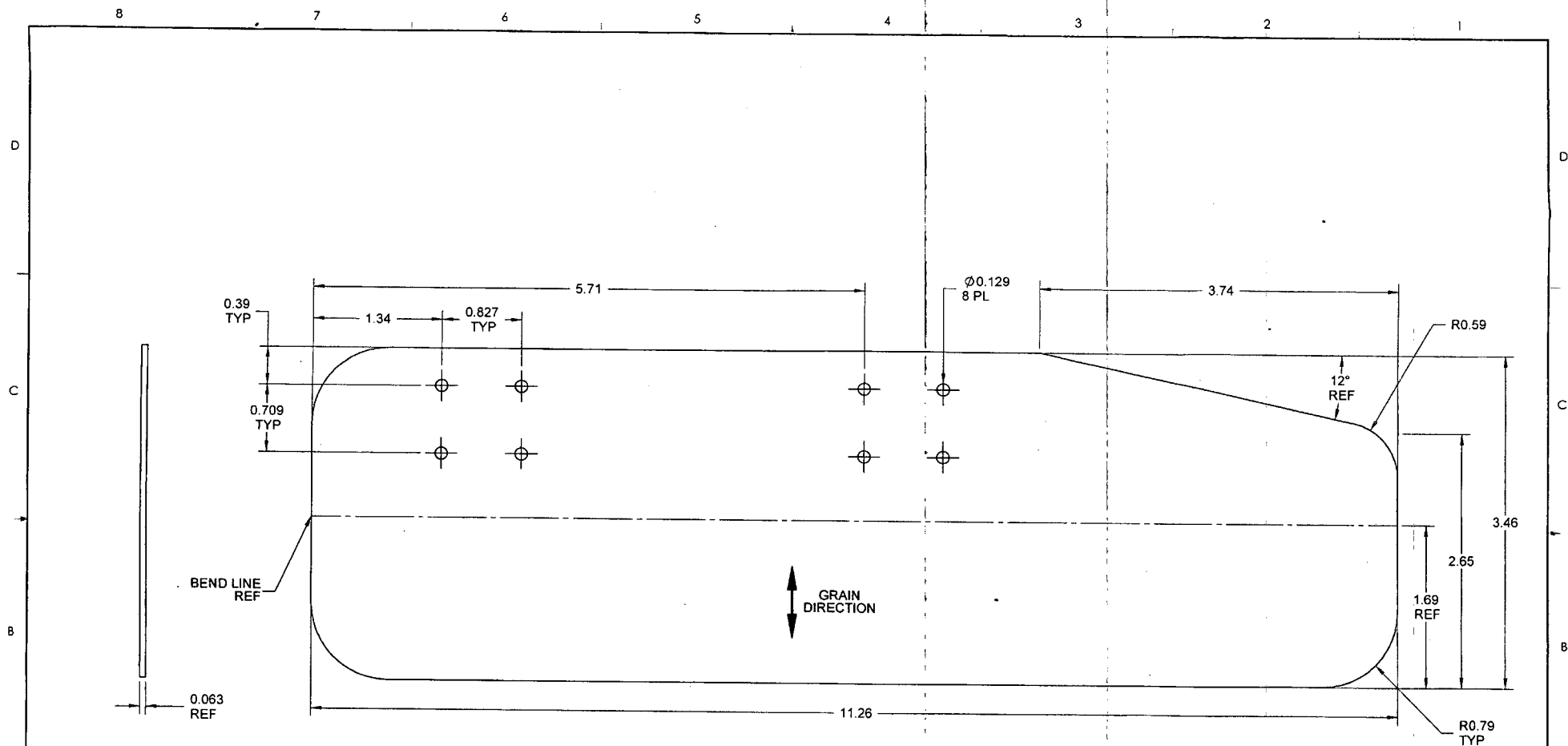
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4006-1F FLAT PATTERN**

*w/o 59567*

**RELEASED**  
R 2010-05-05  
MT

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4006	SHEET 3 OF 6
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

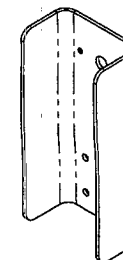
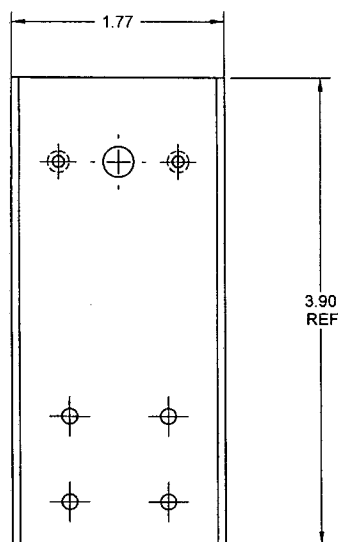
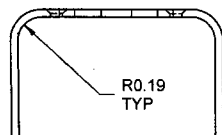
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NOTE: Date & initial all entries



DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-3	REF JCA-M47-2-01



**D4006-3 CHANNEL**

*wlo 59507*

**RELEASED**  
2010-05-05  
*MP*

- NOTES:**
- 1) MATERIAL: MADE FROM D4006-3F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.08 lbs

DESIGN	<i>EB</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>EB</i>	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	<i>EB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>EB</i>	D4006	SHEET 4 OF 6
APPROVED	<i>EB</i>	TITLE	SCALE
DE APPR.	<i>EB</i>	UPPER RESTRAINT	NTS
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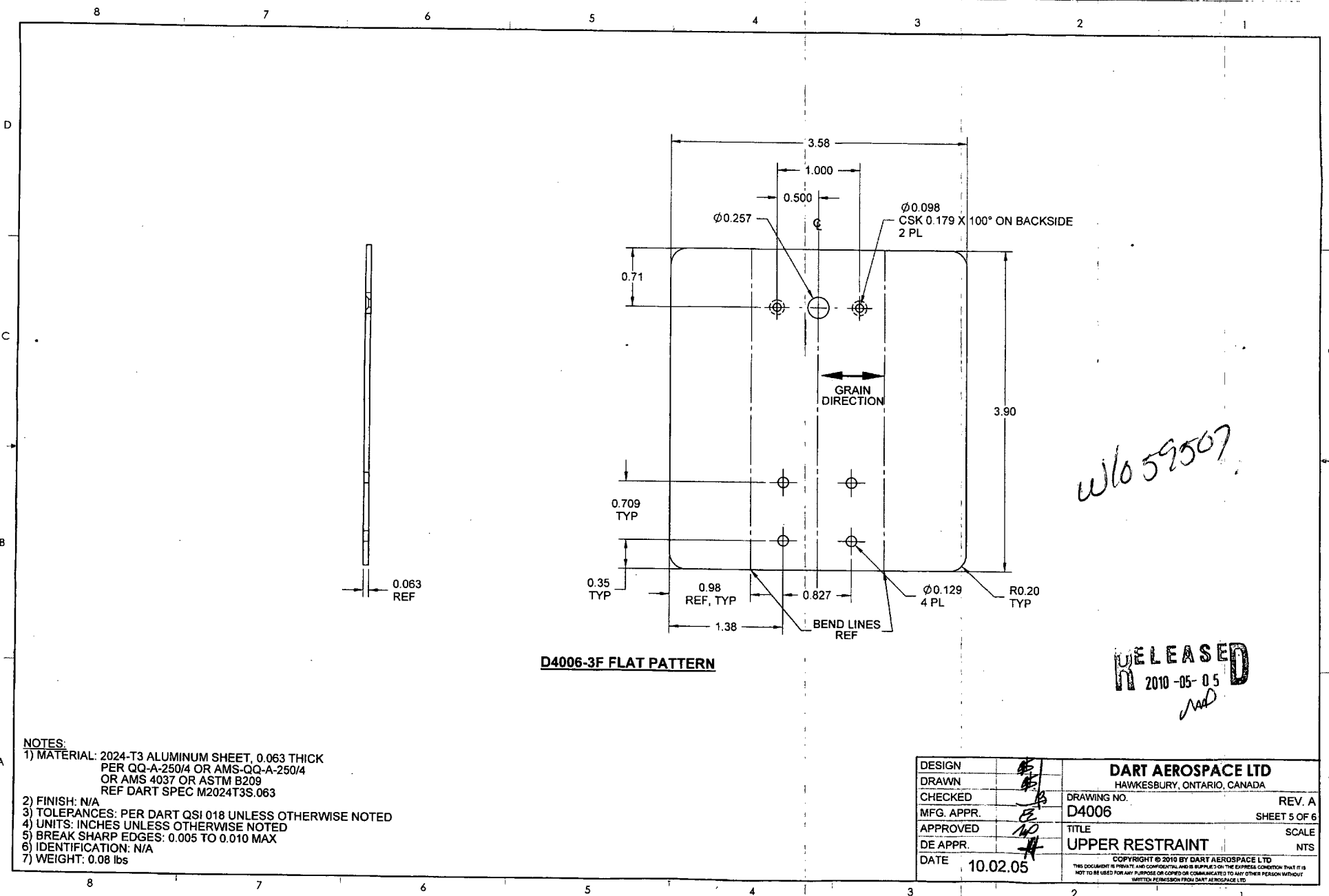
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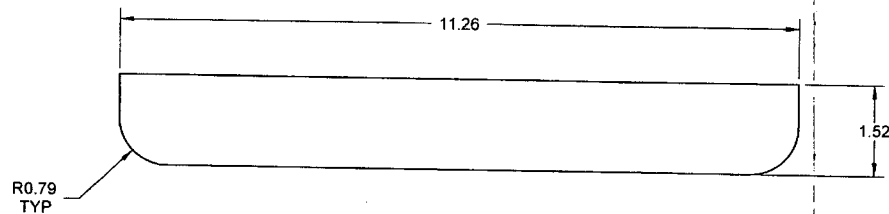
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-5	REF JCA-M47-2-01



**D4006-5 FOAM**

*w/o 59507*

**RELEASED**  
2010-05-05  
*MD*

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK  
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1  
REF DART SPEC M-4111N-S.125
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4006	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		UPPER RESTRAINT	NTS
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**NOTE:** Date & initial all entries

**L Lacelle**

**From:** Harvey Siemens [hsiemens@dartaero.com]

**Sent:** July 12, 2010 10:28 AM

**To:** 'L Lacelle'

**Subject:** RE: D4006-041

Good morning Linda,

Let's use the 3M 1300 contact cement to attach the foam.

Regards,

*Harvey Siemens*

Mechanical Designer

DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: [hsiemens@dartaero.com](mailto:hsiemens@dartaero.com)

W: [www.dartaero.com](http://www.dartaero.com)

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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**From:** L Lacelle [mailto:llacelle@dartaero.com]

**Sent:** Friday, July 09, 2010 6:37 AM

**To:** 'Harvey Siemens'

**Subject:** D4006-041

Hi Harvey,

The route calls to Apply glue and install foam. What kind of glue is req'd pls.?

Thank You,

Linda Lacelle

Production Manager

Dart Aerospace Ltd

7/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries